



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2747
Job Sheet 173727



Part No: D2747

Job Qty: 250 ea

Part Name: Set Screw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP: B 05.08.22 Reformat KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	250 pcs		3/30/18	0.00	0.00	Purchasing		AT 18/03/12
110	Packaging	250 pcs		3/30/18	0.00	0.00	Packaging2		APAS 18/03/12
120	QC	250 pcs		3/30/18	0.00	0.00	QC6		11 MAR 12 2018
130	Packaging	250 pcs		3/30/18	0.00	0.00	Packaging3-1		8 MAR 13 2018
140	QC21-SA	250 Ea		3/30/18	0.00	0.00	QC21		21 MAR 13 2018

Part Op 100 - Issue P/O: 3/8"-24 UNF SS Set Screw 7/8" to 1" long Possible Supplier: McMaster Carr

Descriptions: P/N:92311A639

110 - Ensure material release note is attached

DAS
13
9-89

MAR 07 2018

P/O: 39238

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
92311A639	SS Set Screw	250 pcs (1 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	92311A639	250	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition
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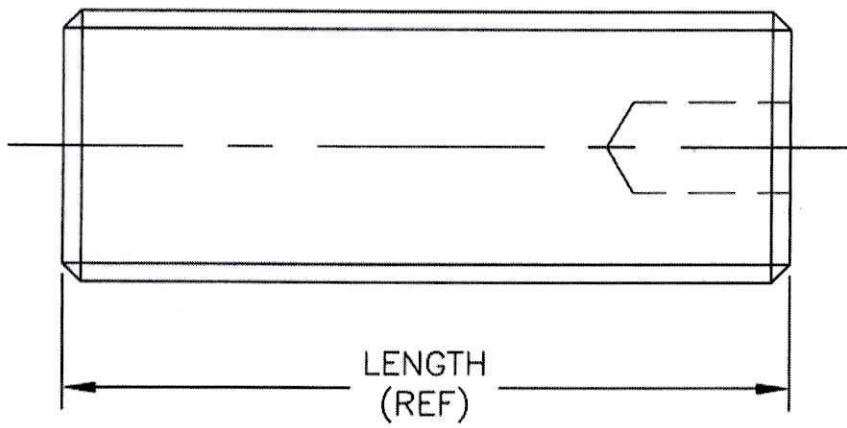
Job No: 173727 Mfg Date: 03/12/18 Packaging Change No: Operation: Revision: Serial No/Batch: S050339 PART NO: D2747 Set Screw 	Completed By
	Lead hand / Supervisor Approval Verification
	QC / QA Coordinator Approval

Root Cause		OTHER :	
Environment ☐	No Re-verification ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Setup ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐		
Material ☐	Use for Testing ☐		
Internal Transport ☐	Poor Information ☐		
Tribal Knowledge ☐	Rushing ☐		
LOA ☐	Product Improvement ☐		
Substation ☐	Process Improvement ☐		
Past Expiry Date ☐	Manufacturing Process ☐		
Misidentified ☐	Past Due ☐		



DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05.08.09



D2747 SET SCREW

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193727 M.C.S
1803-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039238

Supplier: MCM001-VU
McMaster-Carr Supply Co.
P.O. Box 7690
Chicago, IL 60680-7690 USA
Phone: 330 995 5500
Fax: 330 995 9600

PO No: PO039238

PO Date: 3/7/18

Due Date: 3/12/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
MAR 08 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: 2% 10 Net 30

Freight Terms:

Special Comments:

Items											
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price	
1	92311A639	D2747	SS Set Screw	Firmed	3/12/18	250 pcs	0 pcs	250 pcs	\$0.626/pcs	\$156.50	
2	91525A120		washer : AS PER DWG D3456 REV.A	Firmed	3/12/18	50 pcs	0 pcs	50 pcs	\$0.232/pcs	\$11.60	
3	92311A564	D3533-1	Set Screw	Firmed	3/12/18	200 pcs	0 pcs	200 pcs	\$0.2374/pcs	\$47.48	
4	6541K38	D5528-1	Ear Clamp receive pcs	Firmed	3/12/18	25 Ea	0 Ea	25 Ea	\$0.3832/Ea	\$9.58	
5	6519T14	D5528-1	Tubing 10 pcs of 10 ft long	Firmed	3/12/18	10 Ea	0 Ea	10 Ea	\$48.20/Ea	\$482.00	
6	98378A909	1/pk	Perforator Pin .129" X 2-1/2"	Firmed	3/12/18	12 Ea	0 Ea	12 Ea	\$5.92/Ea	\$71.04	
7	188-FPSS- 1/4 20-3/8	92313A535 25/pk	Set Screw	Firmed	3/9/18	50 Ea	0 Ea	50 Ea	\$0.1628/Ea	\$8.14	
Line Item Note please ship item overnight fed ex on acct: 151793240											
8	91292A127	50/pk	Socket Head Cap Screw, M5 x 0.8mm x 18mm receive ea	Firmed	3/12/18	50 Ea	0 Ea	50 Ea	\$0.528/Ea	\$26.40	
9	90327A157	25/pk	Socket Head Cap Screw M8 x 1.25 x 20mm receive ea	Firmed	3/12/18	25 Ea	0 Ea	25 Ea	\$0.0812/Ea	\$2.03	
10	90128A249	100/pk	Socket Head Cap Screw M5 x 0.8 x 25mm receive ea	Firmed	3/12/18	100 Ea	0 Ea	100 Ea	\$0.0812/Ea	\$8.12	
11	92005A218	100/pk	Pan Head Screw M4 x 0.7 x 8mm receive ea	Firmed	3/12/18	100 Ea	0 Ea	100 Ea	\$0.0812/Ea	\$8.12	
12	23065A504	SIZE: 0.3070"	Plug No-Go Gauge receive ea	Firmed	3/12/18	6 Ea	0 Ea	6 Ea	\$3.89/Ea	\$23.34	

Plex 3/8/18 11:27 AM dart.lavoie.chanta

Items										
Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
13	35355T26	1/pk	Anchor Shackle	Firmed	3/12/18	6 Ea	0 Ea	6 Ea	\$9.28/Ea	\$55.68
						6x		AT 18/03/12		
14	35685T55	1/pk	D-Shackle w/Elongated Body	Firmed	3/12/18	6 Ea	0 Ea	6 Ea	\$12.01/Ea	\$72.06
						6x		AT 18/03/12		
15	3440T55	50 ft	Lifting Cable	Firmed	3/12/18	50 Ea	0 Ea	50 Ea	\$1.34/Ea	\$67.00
						50x		AT 18/03/12		
16	3494T12		Lifting Thimble receive ea	Firmed	3/12/18	40 Ea	0 Ea	40 Ea	\$0.66/Ea	\$26.40
						40x		AT 18/03/12		
17	3755T17	2/pk	Lifting Oval Sleeve receive ea	Firmed	3/12/18	30 Ea	0 Ea	30 Ea	\$4.065/Ea	\$121.95
						30x		AT 18/03/12		
18	8948T12		Welded Master Link receive ea	Firmed	3/12/18	4 Ea	0 Ea	4 Ea	\$75.65/Ea	\$302.60
						4x		AT 18/03/12		
19	9657K393	6/pk	Compression Spring	Firmed	3/12/18	12 Ea	0 Ea	12 Ea	\$1.156666/Ea	\$13.88
						12x		AT 18/03/12		
20	98750A317	1/pk	All Thread receive ea	Firmed	3/12/18	20 Ea	0 Ea	20 Ea	\$2.58/Ea	\$51.60
						20x		AT 18/03/12		
21	92196A345	10/pk	Socket Head Cap Screw receive ea	Firmed	3/12/18	200 Ea	0 Ea	200 Ea	\$0.715/Ea	\$143.00
						200x		AT 18/03/12		
22	50715K677	50715K832	Flared Tube Fitting SS	Firmed	3/12/18	20 Ea	0 Ea	20 Ea	\$10.05/Ea	\$201.00
	JLS 173807 05370-1					20x		AT 18/03/12		
23	7856K77	25 ft	Heat Shrink Tubing Color Black	Firmed	3/12/18	25 pcs	0 pcs	25 pcs	\$1.0496/pcs	\$26.24
						25x		AT 18/03/12		
24	90177A218	50/pk	Split Ring Zinc-Plated Steel Split Ring 1" OD, 13/16" ID, 1/8" Thick	Firmed	3/12/18	50 Ea	0 Ea	50 Ea	\$0.2452/Ea	\$12.26
						50x		AT 18/03/12		
25	90174A113	25/pk	Retaining Pin	Firmed	3/12/18	50 Ea	0 Ea	50 Ea	\$0.2756/Ea	\$13.78
						50x		AT 18/03/12		
26	94975A162	1/pk	Quick Release Pin Quick Release Pin W/Lanyard	Firmed	3/12/18	12 Ea	0 Ea	12 Ea	\$4.49/Ea	\$53.88
						12x		AT 18/03/12		
27	90272A189	50/pk	Machine Screw screw 8-32/3/16" long	Firmed	3/12/18	50 Ea	0 Ea	50 Ea	\$0.0608/Ea	\$3.04
						50x		AT 18/03/12		
Grand Total:										\$2,018.72

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/8/18 11:27 AM dart.lavoie.chan@dart.com

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO039238

Order Placed By
Chantal Lavoie

McMaster-Carr Number
8348265-02

Page 1 of 1

03/08/2018

Line	Product	Ordered	Shipped
1	92311A639 18-8 Stainless Steel Cup-Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	25 Packs	25
2	91525A120 316 Stainless Steel Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1" OD, Packs of 25	2 Packs	2
3	92311A564 18-8 Stainless Steel Cup-Point Set Screw, 1/4"-28 Thread, 1" Long, Packs of 50	4 Packs	4
9	90128A249 Zinc-Plated Alloy Steel Socket Head Screw, M5 x 0.8 mm Thread, 25 mm Long, Packs of 100	1 Pack	1
20	92196A345 18-8 Stainless Steel Socket Head Screw, 5/16"-24 Thread Size, 1-3/4" Long, Packs of 10	20 Packs	20

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Shipped separately from our Chicago warehouse on 03/08

6	98378A909 Precision-Sized Flat-Head Core Pin Blanks, 0.129" Diameter, 2-1/2" Long	12 Each	12
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